

Ship ASAP! 2/2/06

D130-701-041

Work Order ID 66655



Page 1

Wednesday, February 23, 2011 1:10:05 PM

Item ID: D3172-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Base Assembly

Start Date: 2/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 11/02/23 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3172

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut Qty 4 D3166-1 as per Dwg D3172 2-Cut 3/4" x 3/4" square tubing as per Dwg D3172 3-Drill holes in D3172-3 as per Dwg D3172 4-Debur & Remove all markings from material 5-Weld as per Dwg D3172 using Welding Table and corner Jig & D3172T1 Debur as r

11.06.20

110

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

11.06.20

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8/11/04/70

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66655

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Page 2

Item ID: D3172-041

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Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

pressure wash

1X ϕ m-l 11/06/21

Memo

1ST COAT:

START TIME: 11:45

OVEN TEMPERATURE: 400 OF

FINISH TIME: 12:15

0.00

1X ϕ m-l 11/06/21

***** 2nd coat if necessary *****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

1 ϕ m-l 11/06/21

M116964

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 66655

Page 3

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Stop



Item Name: Basket Base Assembly

Start Date: 2/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location

0.00



Packaging

Memo

G.A.
w/o
69830

0.00

EP 11/06/22



Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/22

MF
11-06-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Wednesday, February 23, 2011 1:10:01 PM

Page 1

Work Order ID: 66655

Parent Item: D3172-041

Parent Item Name: Basket Base Assembly



Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 04.01.05 Added Step 5 inspection KJ/RF
IPP Rev:C 08-08-29 revC as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2012-117		Manufactured	No			100	Each	24.0000	2	2			
Clevis													

Location

Loc Qty

Loc Code

WA

24

55729

24

D2232-3		Manufactured	No			100	Each	8.0000	2	2			
Basket Hinge													

Location

Loc Qty

Loc Code

WA

8

64578

2

65418

6

D2327-3		Manufactured	No			100	Each	24.0000	2	2			
Spacer Bushing													

Location

Loc Qty

Loc Code

WA

24

58974

1

64920

8

66087

15

PL11.06.20

PL11.06.20

B69211 -> (2)

PL11.06.20

370724 -> (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, February 23, 2011 1:10:01 PM

Work Order ID: 66655

Parent Item: D3172-041

Parent Item Name: Basket Base Assembly

Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00

D2581

Manufactured No

100

Each

24.0000

2

2



Mounting Bracket



PL 11.06.20

Location

Loc Qty

Loc Code

WA

24

64112

1

65950

23

B69737 → (2)

D3166-1

Manufactured No

100

Each

20.0000

4

4



Basket Hoop



PL 11.06.20

Location

Loc Qty

Loc Code

WA

20

64842

8

65458

12

B70188 → (4)

D3174-1

Manufactured No

100

Each

5.0000

8

8



Mounting Lug



PL 11.06.20

Location

Loc Qty

Loc Code

WA

5

59636

5

B66816 → (5)

B69935 → (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Wednesday, February 23, 2011 1:10:02 PM

Work Order ID: 66655

Parent Item: D3172-041

Parent Item Name: Basket Base Assembly



Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F Purchased

No

100

sf

957.6539

48

48



Expanded Metal Flat SS



Pl 11-06-20

Location

Loc Qty

Loc Code

MAT

957.653933

114809

78.622943

114853

11.80059

115012

243.963

115401

20.6845

115989

46.5313

116178

3.0206

116508

33.3012

116768

199.7298

116795

320

m117898 -> 48.

M304TS0.750W.065

Purchased

No

100

f

1,309.455

51

53.68421



304 SQ Tube .75x.75x.065W



SAD 11-06-14

Location

Loc Qty

Loc Code

MAT

1309.4551

112398

0

116267

309.4551

116763

1000

m117598

m1115

53,6843

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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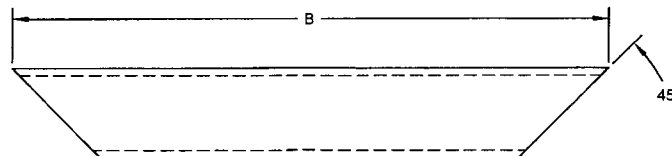
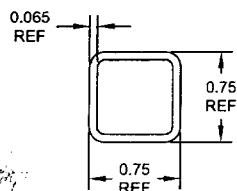
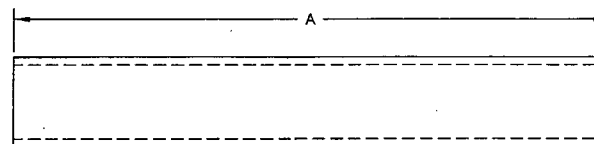
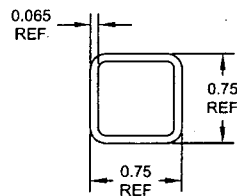
PARTS LIST FOR D3172-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3172-1	2	—	96.00	RIB
D3172-3	2	—	25.50	RIB
D3172-5	6	33.09	—	RIB
D3172-7	3	26.81	—	RIB
D3172-9	1	94.50	N/A	RIB
D2012-117	4	N/A	N/A	CLEVIS
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D3166-1	4	N/A	N/A	RIB
D3174-1	8	N/A	N/A	MOUNTING LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 66653

CL11/02/23







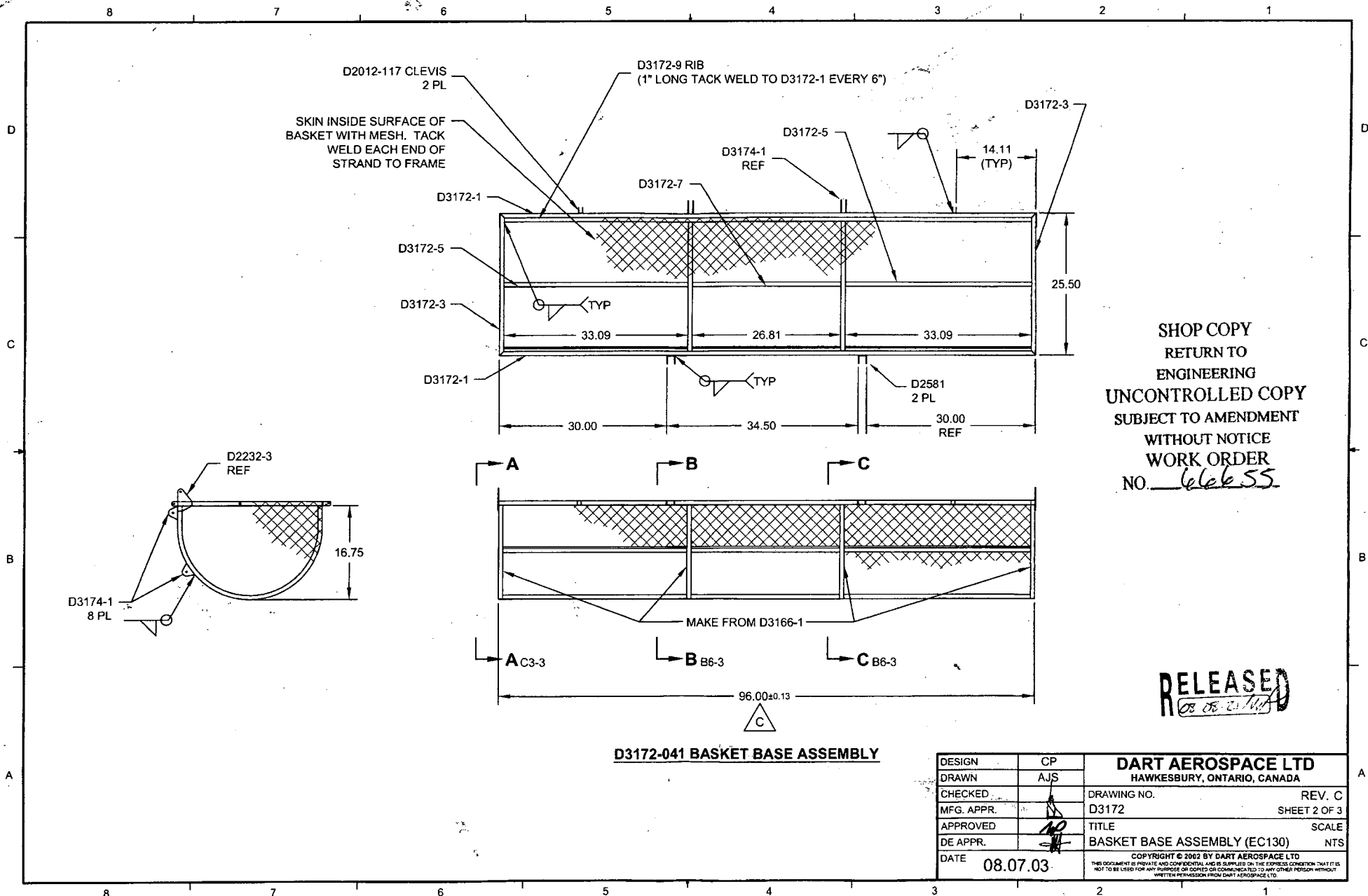
RELEASED
08.07.21/10



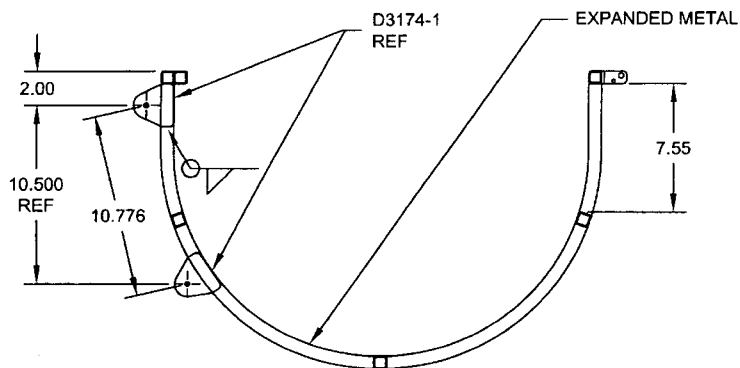
NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750V.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

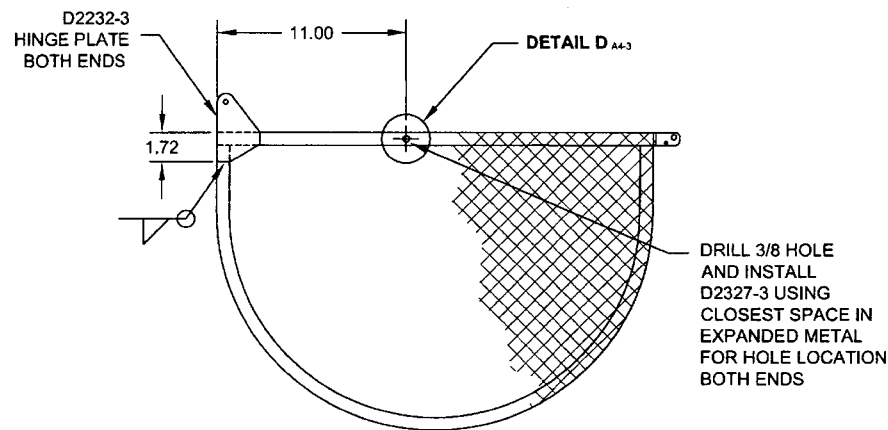
C	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.03	
B	ADD D3172-9 & D2012-117	CP	03.01.07	
A	NEW ISSUE	DS	02.12.02	
REV.	DESCRIPTION	BY	DATE	
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.		DRAWING NO. D3172		REV. C
		TITLE		SHEET 1 OF 3
		BASKET BASE ASSEMBLY (EC130)		SCALE
				NTS
DATE	08.07.03	COPYRIGHT © 2002 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		



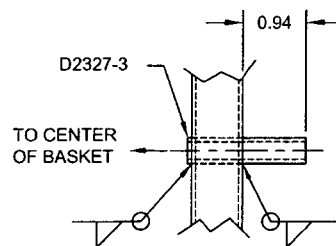
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**SECTION B-B^{B5-2}
AND SECTION C-C^{B3-2}**
RIB DETAIL
SCALE 2X



SECTION A-A^{B5-2}
SPACER DETAIL
SCALE 2X



DETAIL D^{D3-3}
SCALE 4X

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66655

RELEASED
08-08-21/14

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3172	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (EC130)	NTS
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8 7 6 5 4 3 2 1